| Work Orde | | 000 | | *111000* | | | | | | | | | |
|---|---------------|--------------------------------------|----------------------|----------------------|-----------------------|--------------|--------------|---------------|---------------|------------------|----------------|--|--|
| Item ID: Revision ID: Item Name: | D3595-063-450 |) | | Accept | *N900 | 1 040 | Setup Sta | | S1* | | | | |
| Start Date: Required Date: Reference: | 1/08/14 | Start Qty: 10.00 Req'd Qty: 10.00 | *10* *10* | | Cust Item Customer | | | | | "IN | ⊃ /" | | |
| Approvals: | Process Plan: | MIJ | Date: 14-01-10 | Tooling: | | Date: | _ | I | Run Sta | ~1/7 | R1* | | |
| | | | • | | Date: | | | | Sto | , *V | R2* | | |
| Sequence ID/ Work Center II | | Operation Description | | Set Up/ Run Hours | Tool ID | Tool# | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp | | |
| Draw Nbr | Revision | on Nbr | , | | | | | | | | | | |
| D3595 | Rev A | | | | | | | | | | | | |
| 100 | | | | 0.00 | | | | | | | | | |
| *100* | F | LOW WATER JET | | | | | | 10 | _ 0_ | | JM14-02-21 | | |
| Waterjet FLOW CNC Waterj | int | Memo | r Dwg D3595 Dwg Rev: | 0.00 Prog Rev: | 2 | | | | | | | | |
| neo 80 .1 | | Deburr if ne | | Prog Rev: 7- | 2- | | | | | | | | |
| 110 | Q | C2- Inspect parts off m | nachine FAI/FAIB | 0.00 | | | | | | · | | | |
| *110* | | | | | | | | 10 | 0 | | JM14-02-21 | | |
| QC Quality Control | | Memo | | 0.00 | | | | | | | | | |
| 120 | Q | QC8- Inspect parts - seco | ond check | 0.00 | | | | | | | | | |
| *1 20* | | 3.5 | | 0.00 | | | | 10 | <u> </u> | | MM 14.02.20 | | |
| 110 *110* QC Quality Control | Q | OC2- Inspect parts off m Memo | nachine FAI/FAIB | 0.00 | | | | | | | Jm14-0 | | |

Memo

Quality Control

| DQA: | | | Date: | | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | | | | |
|----------------------|-------------|--------------------|------------|-------|-------------|-------------------------------------|--------------|------------------------|--------------------------|-----------|-----------------|---------------|--------------------|--|--|--|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | NFO | RMANCE / UPDA I | | ork Order un | date only | AEROSPACE | | | |
| QA Closed. | | | Date. | | | | . | Work Order update only | | | | | | | | |
| Work Orde | Work Order: | | | | DISPOSITION | | | AG | GAINST DEI | PARTMENT/ | ARTMENT/PROCESS | | | | | |
| WOIN OIG | | | | | | Rework | | Skid-tube Crosstu | | | | Water Jet | Engineering | | | |
| Part N | No. | | | | | Scrap | | | | nall Fab | Prod | d. Eng. Coor. | Quality | | | |
| | • | | | | | Use-as-is | | | Ŭ | nishing | | e/Packaging | Other | | | |
| NCR I | No. | | | | | Suspected Unapproved | | | | nposite | | Supplier | | | | |
| | | | | | | | | | | | | | | | | |
| Root | j | | | | Desci | ription of work order update | 1 | nitial | Action | | Sign & | | | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Description | 1 | Date | Verification | QC Inspector | | | |
| Design | Щ | | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | İ | | | | | | | | | | | | | |
| Handling/Pre | Н | | | | | | | | | | | | | | | |
| Material | Н | | | | | | | | | | | | | | | |
| Operator | Н | | | | | | | | | | | | | | | |
| Offset/Setup | Н | | | | | | | | | | | | | | | |
| Process | \vdash | | | | | | ļ | | | | | | | | | |
| Supplier Training | Н | | | | | | | | | | | | | | | |
| Transport | Н | | | | | | | | | | | | | | | |
| Unapproved | Н | | | | | | | | | | | | | | | |
| - | | | | | | · | FAI | ULT CA | TEGORY | | | | 1 | | | |
| Landi | ng G | Gear | | | | General | | | w | | | | | | | |
| | | Bending | | | | Bend | | Folio/F | Program | | Outside Dim | ensions | Pressure/Forced | | | |
| | | Centre No | ot Concer | ntric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up | | | |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorred | :i | Temperature/Cure | | | |
| | | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/Unqualifi | ied | Part Lost/Mi | ssing | Weld | | | |
| | | Cuffs | | | | Contamination | | Instruc | tions Incomplete/Unclear | r | Part Moved | | Wrong Stock Pulled | | | |
| | | Crushing | | | | Countersink | | Misali | gned/off center | | Positioned V | /rong | _ | | | |
| | | Heat Trea | at | | | Cut Too Short | | Mislab | eled | | Power Loss/: | Surge | Other | | | |
| | | Inspectio | n Strip in | Tube | | Drawing | | Misrea | d | | | | | | | |
| | L | Marks/Ch | | | | Drill Holes | \perp | Off-set | | | | | | | | |
| | | Turning S | • | | | Finish | | 1 | Calibration | | | | | | | |
|] | | Wave/Twist in Tube | | | 1 | Fit/Function | | Out of | Sequence | | | | | | | |

Work Order ID 111000 *111000* Page 2 January-08-14 12:49:25 PM Item ID: D3595-063-450 Accept *N900040100* Setup Start **Revision ID: Item Name: Rubber Cushion** *10* **Start Qty: 10.00 Start Date:** 1/08/14 **Cust Item ID:** Required Date: 1/08/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Start **Approvals:** Process Plan: Date: Tooling: Date: Stop Date: SPC (Y/N): QC: Date: Reject Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Insp. Number Stamp **Work Center ID Description Run Hours** Code Qty Qty Identify as per dwg & Stock Location: Crossible 0.00 130 *120* ASS'N Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 14.02-24 *140* OC 0.00 Memo Quality Control

| DQA: | Date: | | | | | WORK ORDER NON-CONFORMANCE / UPDATE | | | | | | | | | | |
|---------------|-------------|--------------------|-----------|-------|-------------|-------------------------------------|----------|----------------------------|---------------------|-------------|------------------|--------------|--------------------|--|--|--|
| 0.4.61 | | | Data | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UPD | | ork Order up | odato only | AEROSPACE 1 | | | |
| QA Closed: | | | Date: | | | | 1 | | | V | rork Order up | date only | <u></u> | | | |
| Work Orde | Work Order: | | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | | | | |
| | | Rework | | | Skid-tube | Crosstube | 7 | Water Jet | Engineering | | | | | | | |
| Part N | lo. | | | | | Scrap | | | Machining | Small Fab | Prod. Eng. Coor. | | Quality | | | |
| | - | | | ··· | | Use-as-is | | Therr | noforming | Finishing | Rec/Stor | e/Packaging | Other | | | |
| NCR N | lo. | | | | | Suspected Unapproved | | | Large Fab | Composite _ |] | Supplier | | | | |
| | | | | | | | | | | | | | | | | |
| Root | | | | | Desc | ription of work order update | | nitial | Actio | n | Sign & | | | | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descrip | tion | Date | Verification | QC Inspector | | | |
| Design | | | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | ļ | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | | | |
| Material | Ш | | | | | | 1 | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | |
| Offset/Setup | | | | | ļ | | 1 | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | l | | | | | | | | | |
| Training | | | | | | • | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | | | |
| Unapproved | | | <u>.</u> | | | | <u></u> | | <u> </u> | | 1 | | | | | |
| | | | | | | | FA | ULT CA | TEGORY | | | | | | | |
| Landi | ng (| 1 | | | _ | General | _ | 1 | | _ | | | 7 | | | |
| | | Bending | | | | Bend | \vdash | 4 | Program | <u> -</u> - | Outside Dim | <u> </u> | Pressure/Forced | | | |
| | | Centre N | ot Concer | ntric | <u> </u> | BOM/Route | <u> </u> | Grain | | <u> </u> | Over/Under | | Set-up | | | |
| | <u> </u> | Cracks | | | <u> </u> | Broken/Damage/Defect | | Hardwa | | <u>_</u> | Part Incorre | | Temperature/Cure | | | |
| | _ | Crimp/Ki | nk/Ripple | /Wave | <u> </u> | Burrs | <u> </u> | -l ' | tion Incomplete/Unq | | Part Lost/Mi | issing | Weld | | | |
| | - | Cuffs | | | | Contamination | <u> </u> | -1 | tions Incomplete/Un | clear | Part Moved | | Wrong Stock Pulled | | | |
| | - | Crushing | | | <u> </u> | Countersink | \vdash | - | gned/off center | <u> </u> | Positioned V | | ا ما | | | |
| | _ | Heat Trea | | _ | | Cut Too Short | Ľ. | Mislab | | | Power Loss/ | Surge | Other | | | |
| | <u> </u> | Inspectio | - | Tube | <u> </u> | Drawing | \vdash | Misrea | | | | | | | | |
| | L | Marks/Cl | | | | Drill Holes | <u></u> | Off-set | | | | | | | | |
| | | 4 | Sequence | | | Finish | <u>_</u> | 4 | Calibration | | | | | | | |
| i | 1 | Wave/Twist in Tube | | | | Fit/Function | | Out of | Sequence | | | | | | | |

Page 1

Work Order ID:

111000

Parent Item:

1 > 3

D3595-063-450

Parent Item Name:

Rubber Cushion

Start Date: 1/08/14

Required Date: 1/08/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-08-07 JLM Verified By:

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------------------|---------------|----------------|----------|
| MNEO80S.125 NEOPRENE SHEET 0.125 | | Purchased | No | | | 100 | sf | 746.9344 | 0.0196 | . 0.20631 6 O | · S | Jn | 14-07-21 |

| DQA: | Date: | | | | | • | | | | | | | | ~DART |
|--------------------|--------------|----------------------------------|-------------|----------------|-------------|------------------------------|----------|---------------------|--------------------|---------------------------------------|------------------|---------------|--------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UF | | Mα | rk Order up | ndate only | AEROSPACE |
| QA Closed. | | | Date. | | | | | | | | | | | |
| Work Order: | | | | DISPOSITION | | | | | | | | | | |
| | • | | | | | Rework | | Skid-tube Crosstube | | | | | Water Jet | Engineering |
| Part N | lo. | | | | | Scrap | | | Machining | Small Fab | Prod. Eng. Coor. | | | Quality |
| | • | | | | | Use-as-is | | Thern | noforming | Finishing | | Rec/Stor | e/Packaging | Other |
| NCR N | lo. | | | | | Suspected Unapproved | | | Large Fab | Composite | | | Supplier | |
| | | | | | _ | | | | | | _ | c: 0 | | |
| Root | | . . | c | <u>.</u> | Desci | ription of work order update | ı | nitial | Acti | | | Sign & | Varification | OC Inspector |
| Cause | | Date | Step | Qty | | or non-conformance | Cn | ief Eng | Descri | iption | - | Date | Verification | QC Inspector |
| Design Doc/Data | \dashv | | | | | | | | | | ı | | | |
| Equip/Tooling | Н | | | | | | ĺ | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | · |
| Material | | | | | | | | | | | - | | : : | |
| Operator | | | | • | | | ļ | | | | | | | |
| Offset/Setup | | | | | ļ | | İ | | | | | | | |
| Process | | | | | | | | | | | | | | |
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| Training | | | | | | | | | | | | | | |
| Transport | | | | | | | İ | | | | | | | |
| Unapproved | | . <u> </u> | | | | | <u> </u> | | <u></u> | | | | | |
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| Landi | ng (| 1 | | | | General | |]:_/ | D | Г | \neg | Outside Dim | | Pressure/Forced |
| | | Bending Centre N | at Canaar | atria | | Bend BOM/Route | \vdash | Grain | Program | - | | Outside Diffi | — | Set-up |
| | | 1 | or concer | TUTIC | ⊢ | Broken/Damage/Defect | - | Hardwa | ara | | - | Part Incorre | [| Temperature/Cure |
| | \vdash | Cracks Crimp/Kink/Ripple/Wave | | <u> </u> | Burrs | \vdash | 1 | tion Incomplete/Ur | ngualified | | Part Lost/Mi | _ | Weld | |
| | | Cuffs | ing rappic | ., , ,, | - | Contamination | | 4 ' | tions Incomplete/L | · · · · · · · · · · · · · · · · · · · | \neg | Part Moved | _ | Wrong Stock Pulled |
|]. | H | Crushing | | | Countersink | | | gned/off center | | _ | Positioned V | ∟ Vrong | _ ~ | |
| | | Heat Trea | | | | Cut Too Short | | Mislab | = | • | | Power Loss/ | _ | Other |
| | | Inspectio | | Tube | | Drawing | Γ | Misrea | d | | | , | | |
| | | Marks/Cl | - | | | Drill Holes | | Off-set | | | • | | | |
| | | Turning S | Sequence | | | Finish | | Out of | Calibration | | | | | |
| | | Wave/Tw | vist in Tub | oe | | → ⊢ | | Out of | Out of Sequence | | | | | |

| DART AEROSPACE LTD | Work Order: | 11000 |
|------------------------------|--------------|---------------|
| Description: Rubber Cushion | Part Number: | D3595-063-450 |
| Inspection Dwg: D3595 Rev: A | | Page 1 of 1 |

| mopeonon bing. B | 1104.7 | | | | | 3 | | | | | | | | |
|-----------------------------------|---------------------------|---------------------|---------|--------|-------------------------|----------|-------------|--|--|--|--|--|--|--|
| | FIRST | ARTICLE IN | SPECTIO | ON CHE | CKLIST | | | | | | | | | |
| | X First Article Prototype | | | | | | | | | | | | | |
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | | ments | | | | | | | |
| 0.63 | +/-0.030 | 0.634 | _ | | 0 | Jano | | | | | | | | |
| 4.50 | +/-0.030 | 4.50" | _ | | U | | | | | | | | | |
| 0.125 | +/-0.010 | 0.125 | | | J | | | | | | | | | |
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| Measured by: \mathcal{J}_{ℓ} | ~ | Audited by: MM | | | Prototype A | pproval: | N/A | | | | | | | |
| Date: / 4 | 1-02-21 | Date: | 14.02 | 24 | | Date: | N/A | | | | | | | |

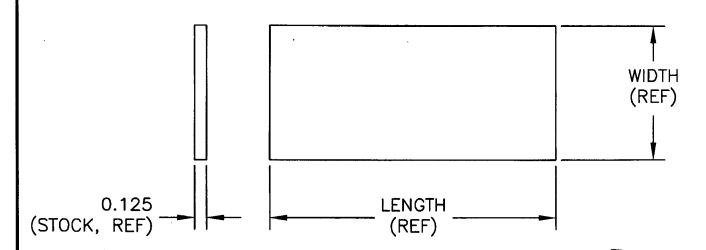
| Rev | Date | Change | Revised by Approved |
|-----|----------|-----------|---------------------|
| Α | 08.01.23 | New Issue | KJ/EC/DD 🛠 |



| DESIG | PH | DRAWN BY | DART AEROSPA HAWKESBURY, ONTARIO | |
|-------|----------------|------------|-------------------------------------|--------------|
| CHECH | (ED :// | APPROVED / | DRAWING NO. | REV. A |
| | - | # | D3595 | SHEET 1 OF 1 |
| DATE | - | | TITLE | SCALE |
| 07.0 | 2.07 | | RUBBER CUSHION | NTS |
| Α | | 07.02.07 | NEW ISSUE | - |



SPECIFICATION CONTROL DRAWING



SPECIFICATION: D3595-XXX-YYY RUBBER CUSHION
WIDTH
LENGTH

EG: 0.75"x4.30" RUBBER CUSHION = D3595-075-430

NOTES

1) MATERIAL: BLACK NEOPRENE SHEET, 0.125 THICK,

80 DUROMETER (REF DART SPEC. M-NEO80-S.125)

2) FINISH: NONE

3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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